

Date: Tuesday, 03/06/2008 1:03:33 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: SPRING		
Job Number	: 39670			Part Number	: D2535		
Estimate Number	: 10497			Drawing Number	: D2535 REV. A		
P.O. Number	:			Project Number	: N/A		
This Issue	: 03/06/2008	S.O. No.	:	Drawing Revision	: A		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: PURCHASED PARTS	Due Date	: 10/06/2008		
Previous Run	: 37071			Qty:	100	Um:	Each
Written By	:			Comment	: Est. A99.04.19 New Issue (From hand written IPP) DM		
Checked & Approved By	: <u>JUL 08.6.03</u>						
Comment	:						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		 Comment: PURCHASING Issue P/O: <u>10491</u> <u>C208/06/04</u> Possible Supplier: Victoria Spring, 0.070 SS Torsion Spring <u>100</u>
2.0	D2535P	Spring
		 Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s) SPRING
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		 Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached <u>P 8/6/12 (100)</u>
4.0	QC6	DIMENSIONAL CHECK
		 Comment: DIMENSIONAL CHECK Check dims to dwg <u>8/08/06/12 x100 located</u>
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>35</u> <u>P 8/6/13 (100)</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08/06/16 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



✓ 08-06-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

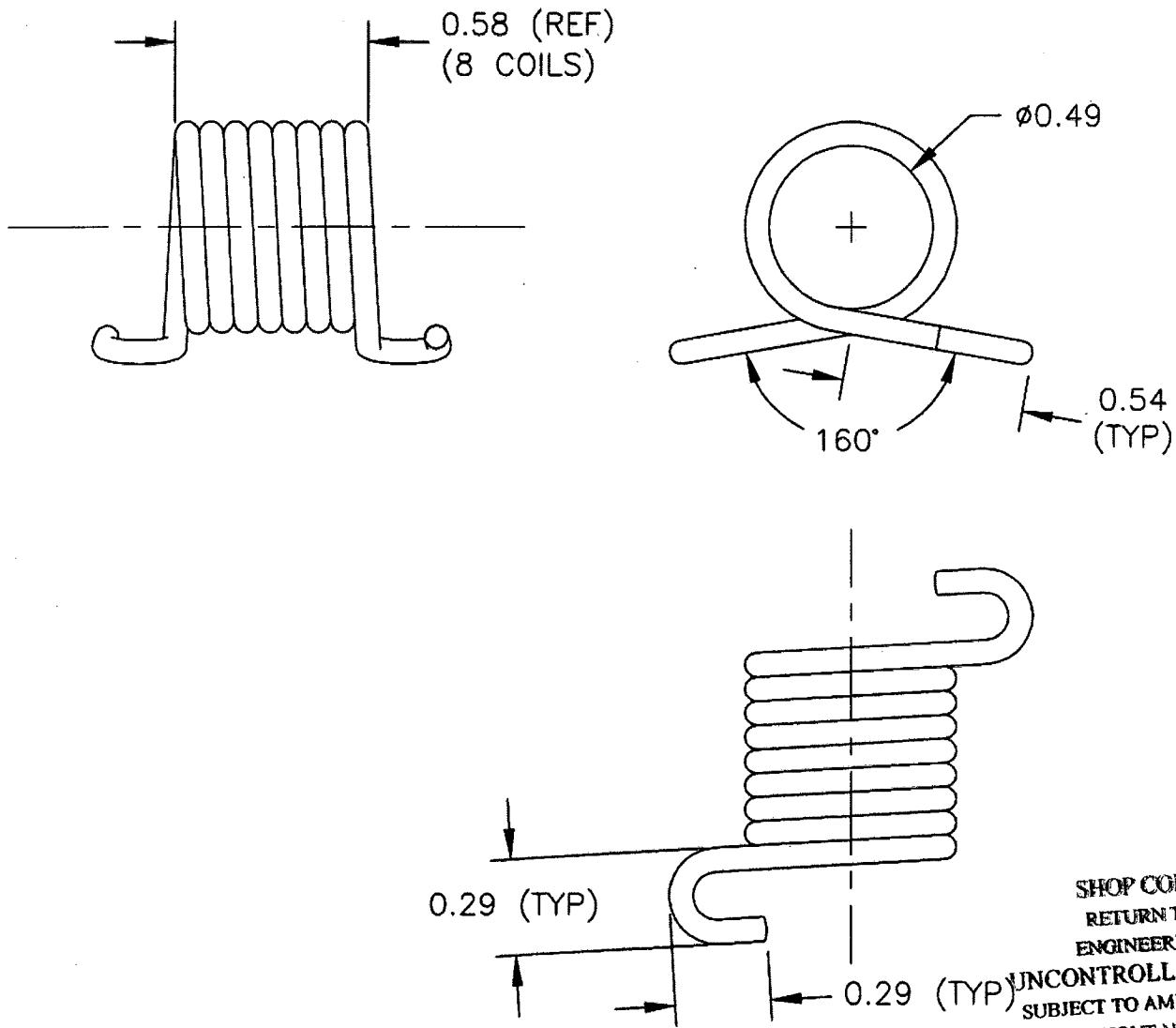
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART1 COPY ISSUED
DRAFT

DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RE	APPROVED JAH	DRAWING NO. D2535	REV. A SHEET 1 OF 1
DATE 99.04.08		TITLE SPRING SPEC CONTROL	SCALE 2:1
A	99.04.08	NEW ISSUE	

RELEASED
99.05.11 KESPECIFICATION CONTROL DRAWING

TENSION SPRING WITH 8 COILS (NO GAP BETWEEN COILS)

MATERIAL: AISI STAINLESS STEEL Ø0.070

POSSIBLE SUPPLIERS: VICTORIA SPRINGS, P/N .070SS TENSION SPRING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Victory Spring Ltd.

CONFORMANCE REPORT

#2, 6104 - 82 Ave, Edmonton, AB T6B 0E7
 Tel: (780) 442-4020 Fax: (780) 466-8000

REPORT FOR:	Dart Aerospace Ltd.	DATE:	6/11/2008
PO #	6491	PART/DRAWING #:	D2535P
SPRING DESCRIPTION:	SS Torsion Spring	QUANTITY:	100

CHARACTERISTIC	SPECIFIED	MEASURED	NOTES
Material type	SS T302	Yes	
Material diameter	.070"	.072"	
I.D.	.490"	.485" / .493"	Min / Max
O.D.			∞
Number of Coils	8 Ref	Yes	
Free Length			
Helix	RHW	Yes	
End type	As per drawing	Yes	
Rate (lb/in)			
Finish			

COMMENTS

Mill Certificate attached: No
 Material Heat Number: N/A

Certified by:

Jeremy Burrowes